

Work Order ID 81344

81344

Page 1

March-13-12 1:34:25 PM

Item ID: D3536-13 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Gasket
 Start Date: 13/03/2012 Start Qty: 16.00 ***16*** Cust Item ID:
 Required Date: 27/03/2012 Req'd Qty: 16.00 ***16*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/03/13 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3536	Rev A								

100 FLOW WATER JET 0.00
100
 Waterjet Memo 0.00
 FLOW CNC Waterjet I-Cut as per Dwg D3536 Dwg Rev: A Prog Rev: A 2-
 Deburr if necessary

B12-3-24

54

110 QC2- Inspect parts off machine FAI/FAIB 0.00
110
 QC Memo 0.00
 Quality Control

B12-3-24

120 QC8- Inspect parts - second check 0.00
120
 QC Memo 0.00
 Quality Control

5.2/3/26

ccantes
724

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 81344

81344

Page 2

March-13-12 1:34:25 PM

Item ID: D3536-13

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Gasket

Start Date: 13/03/2012 Start Qty: 16.00

16

Cust Item ID:

Required Date: 27/03/2012 Req'd Qty: 16.00

16

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location: **STFP.**

0.00

130

Packaging

Memo

0.00

Packaging

(24x) SP12-03-26

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

MLJ 12/03/27

12-03-27

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NOTE: Date & initial all entries

Picklist Print

March-13-12 1:34:31 PM

Page 1

Work Order ID: 81344

81344

Parent Item: D3536-13

D3536-13

Parent Item Name: Gasket

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063		Purchased	No			100	sf	801.7520	0.8269	14.70044			

MNEO60S 06.3

NEOPRENE SHEET 0.063

**

20,
B12-3-21

Location

MAT052

119777

120948

Loc Qty

801.752

3.752

798

Loc Code

120948

24

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DART AEROSPACE LTD		Work Order: 81344
Description: Gasket		Part Number: D3536-13
Inspection Dwg: D3536	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
32.90	+/-0.030	32.90	✓		T B01	
29.40	+/-0.030	29.40	✓		T	
27.40	+/-0.030	27.46	✓		T	
23.90	+/-0.030	23.90	✓		T	
18.98	+/-0.030	18.98	✓		T	
14.07	+/-0.030	14.07	✓		T	
9.15	+/-0.030	9.15	✓		T	
5.65	+/-0.030	5.65	✓		T	
3.90	+/-0.030	3.90	✓		T	
8.00	+/-0.030	8.00	✓		T	
14.00	+/-0.030	14.06	✓		T	
20.00	+/-0.030	20.02	✓		T	
1.89	+/-0.030	1.888	✓		V B02	
0.30	+/-0.030	0.30	✓		V	
0.30	+/-0.030	0.308	✓		V	
Ø0.19	+0.005/-0.001	0.190	✓		V	

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 12-3-09	Date: 12/03/06	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.06.13	New Issue	KJ/JLM	B

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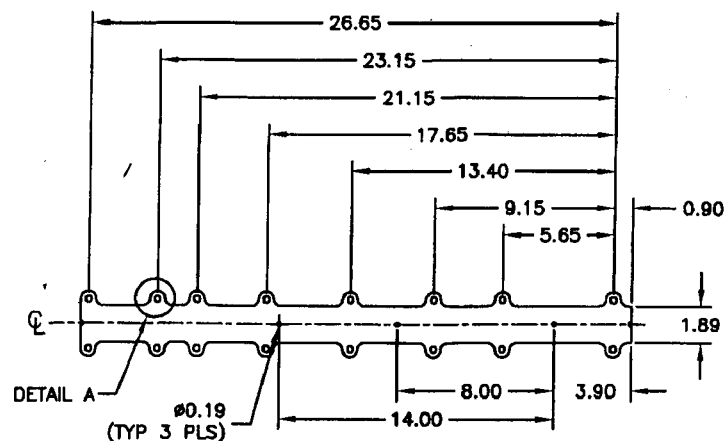
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DART

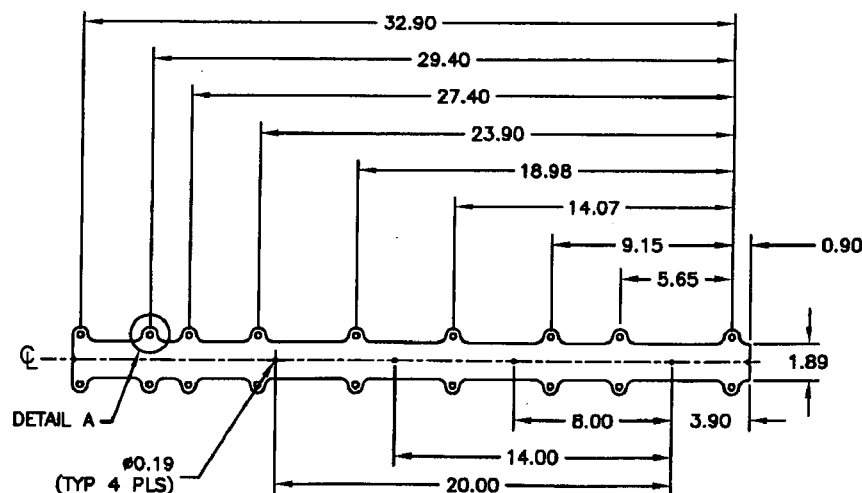
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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 81344 MCT

12/03/13



D3536-11 GASKET



D3536-13 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CB	CB	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
PH	PH	D3536
DATE	TITLE	REV. A
06.10.25	GASKET	SHEET 1 OF 6
A	NEW ISSUE	SCALE
		1:10

Dart Aerospace Ltd

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NOTE: Date & initial all entries

DART AEROSPACE USA, INC.
PORT HADLOCK, WA

PORT HADLOCK, WA

REV. A

DESIGN CB
CHECKED PH

DRAWN BY	CB
APPROVED	<i>[Signature]</i>

DRAWING NO.

DATE _____

06.10.25

QTY	DESCRIPTION	UNIT	PRICE	TOTAL
1	GASKET	EA	1.00	1.00

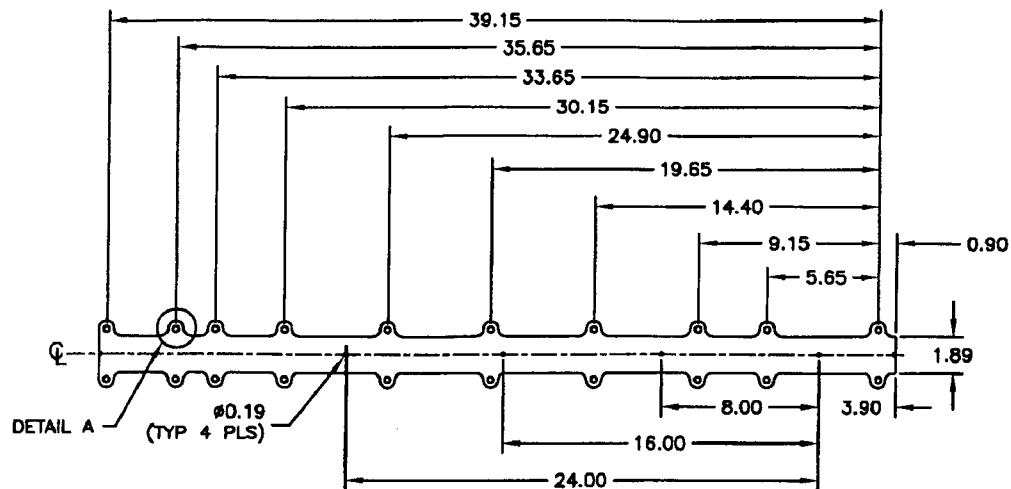
SHEET 2 OF 6

SCALE

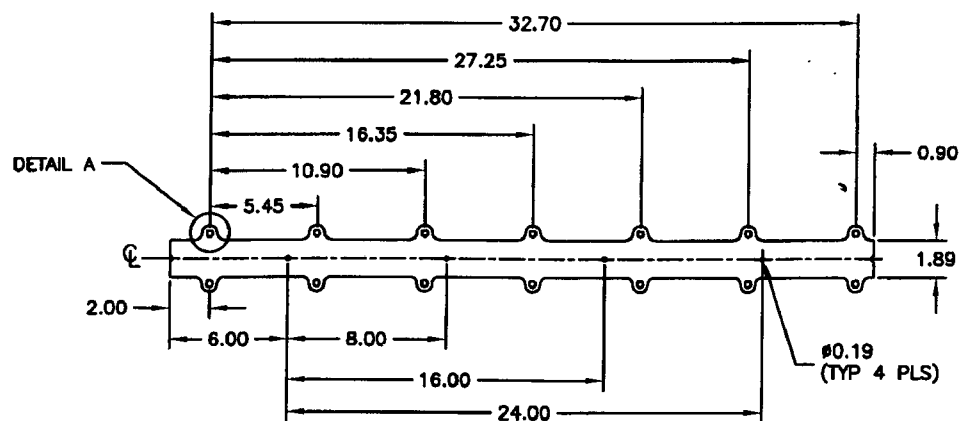
1:10

81344

0702.12 #



D3536-15 GASKET



D3536-21 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
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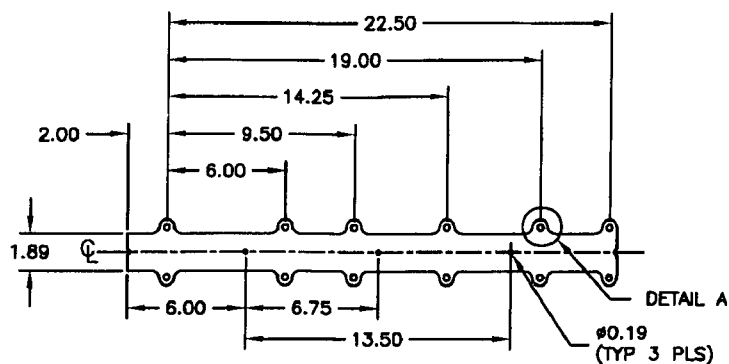
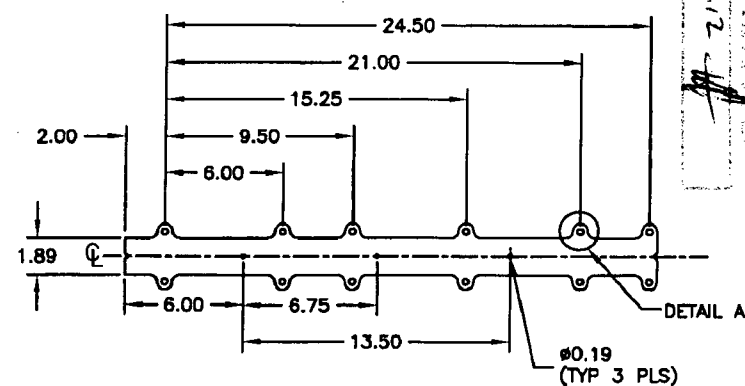
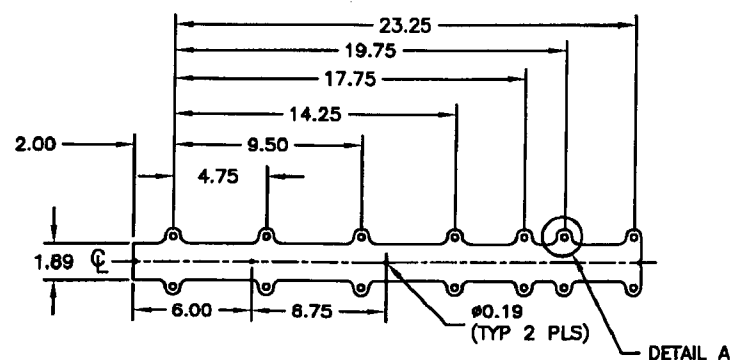
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CB	CB	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. A
PH	PH	D3536	SHEET 4 OF 6
DATE	TITLE	SCALE	
06.10.25	GASKET	1:10	

NOT RECORDED

07.02.12

81344

**D3536-31 GASKET****D3536-33 GASKET****D3536-35 GASKET****NOTES**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
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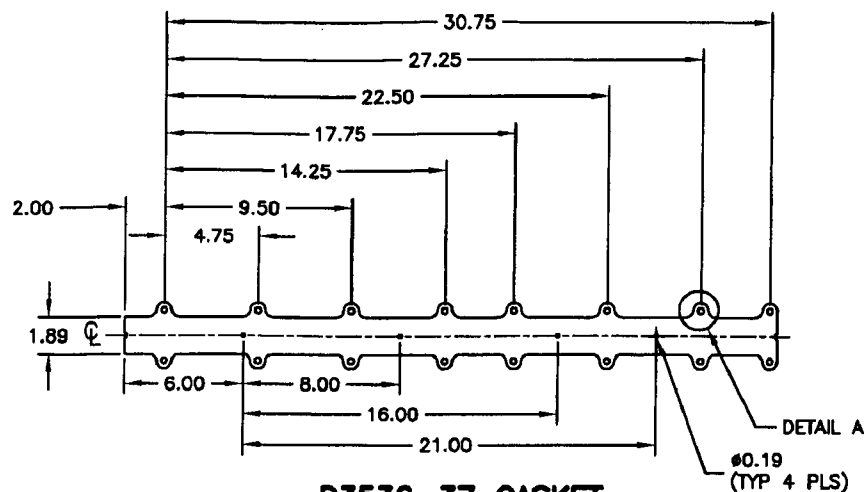
NOTE: Date & initial all entries

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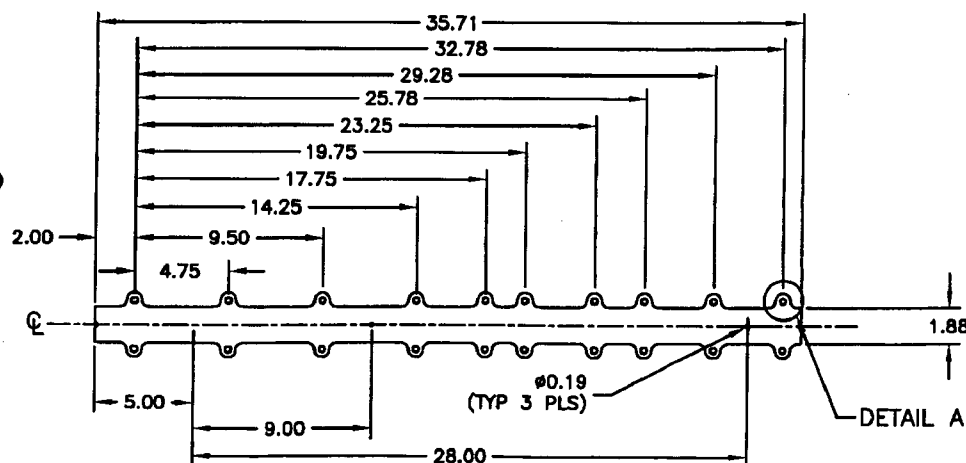
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CHECKED	PH	APPROVED		PORT HADLOCK, WA
DATE	06.10.25	TITLE	D3536	REV. A
			GASKET	SHEET 5 OF 6
				SCALE 1:10

01344

07.02.02



D3536-37 GASKET



D3536-39 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
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Dart Aerospace Ltd

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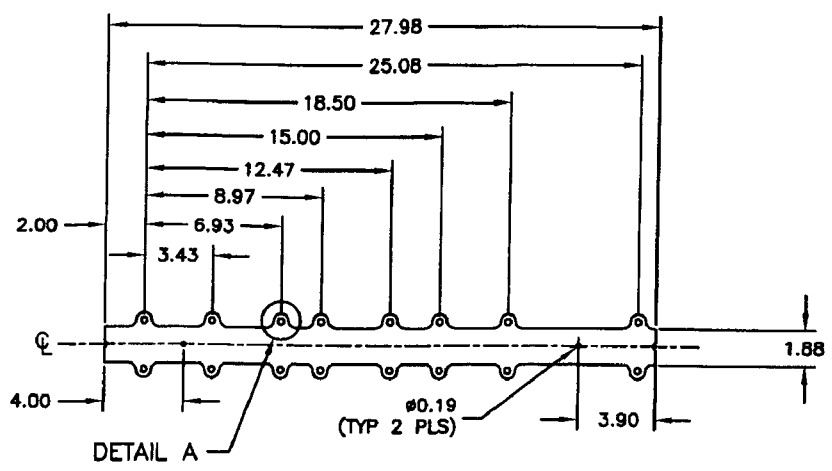
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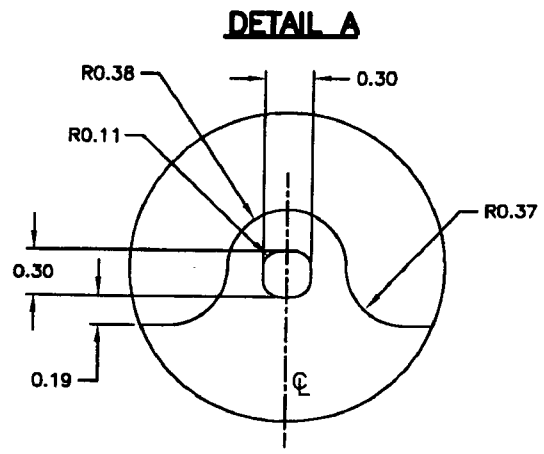
81344

070212 C.B.

DESIGN	C.B.	DRAWN BY	C.B.	DART AEROSPACE USA, INC.
CHECKED	AH	APPROVED	AH	PORT HADLOCK, WA
DATE	06.10.25	DRAWING NO.	D3536	REV. A
		TITLE	GASKET	SHEET 6 OF 6
		SCALE	1:10	



D3536-41 GASKET



NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
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